

**METHOD OF TRANSFERRING LARGE UNCURED COMPOSITE
LAMINATES**

ABSTRACT OF THE DISCLOSURE

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A method of transferring an uncured composite laminate skin from a lay-up surface of a male mandrel tool to a female cure tool includes defining multiple vacuum zones on the lay-up surface, each zone corresponding to one of a multiple of portions into which the skin is to be separated. For example, to
10 separate the skin into two portions, a low profile seal of a first membrane to the lay-up surface is formed at a first vacuum zone and a second low profile seal for a second membrane is formed at a second vacuum zone. The method further includes laying up a composite laminate skin over all the vacuum zones; separating the composite laminate skin into portions, for example, a first portion
15 over the first vacuum zone and a second portion over the second vacuum zone; and releasing the portions individually into cure tools having an outside mold line surface.